

Work Order ID 128175

January-12-15 7:44:04 AM

128175

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Item ID: 647.9201

Revision ID:

Item Name: Upper Cutter Assembly

Start Date: 1/12/15 Start Qty: 5.00

Required Date: 1/13/15 Req'd Qty: 5.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

647.9200

N/C

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

5

DAS
41
9-89

120

0.00

120

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 2.

A/R RTV LOCTITE 598: 125637
exp. date: 5/15

5

DAS
41
9-89

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Item ID: 647.9201 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Upper Cutter Assembly
 Start Date: 1/12/15 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 1/13/15 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							DAS 38 9-88
Quality Control									JAN 14 2015
140	Identify as per dwg & Stock Location <u>CCF57</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS DWG PER APICAL MPP-120 BY LASER ETCH THE P# AND REV***								JAN 14 2015 9-88
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									MLJ 15-01-14

(Handwritten signature and date 15-1-14)

Picklist Print

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Work Order ID: 128175

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Parent Item: 647.9201

647 9201

Parent Item Name: Upper Cutter Assembly

Start Date: 1/12/15

Required Date: 1/13/15

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 12.10.23 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
601.2045 *601 2045* RTV (LOCTITE 598)		Purchased	No				Each	10.0000		5		DAS 41 9-89	15-1-12
					125637				**	1			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				CCK096				10					
				m131142				10					
647.9411 *647 9411* Upper Deflector		Manufactured	No				Each	36.0000		5		DAS 41 9-89	15-1-12
									**				
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				MF				36					
				103415				26		5			
				115252				10					
647.9702 *647 9702* Upper Cutter Sub Assembly		Manufactured	No				Each	5.0000		5		DAS 41 9-89	15-1-12
									**				
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				MF				5					
				109397				5		5			

Picklist Print

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Work Order ID: 128175

128175

Parent Item: 647.9201

647 9201

Parent Item Name: Upper Cutter Assembly

Start Date: 1/12/15

Required Date: 1/13/15

Start Qty: 5.00

Required Qty: 5.00

MS21042L08

Purchased

No

Each

880.0000

15

DAS
41
9-89

15-1-12

MS21042L 08

Nut

**

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST304

779

123900

16

m128401

210

m130325

553

15

MS27039-08-19

Purchased

No

Each

134.0000

15

DAS
41
9-89

15-1-12

MS27039-08-19

Screw

**

Location

Loc Qty

Loc Code

ST273A

134

m130505

134

15

NAS1149FN832P

Purchased

No

Each

5,142.000

30

DAS
41
9-89

15-1-12

NAS1149FN832P

Washer

**

Location

Loc Qty

Loc Code

ST260a

3600

125268

3600

st268

1542

M130388

1542

30

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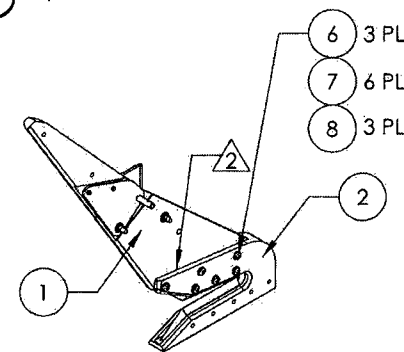
NOTES:

1. IDENTIFY IAW MPP - 120. LASER ETCH P/N AND REVISION, 12 PT. CENTURY GOTHIC.

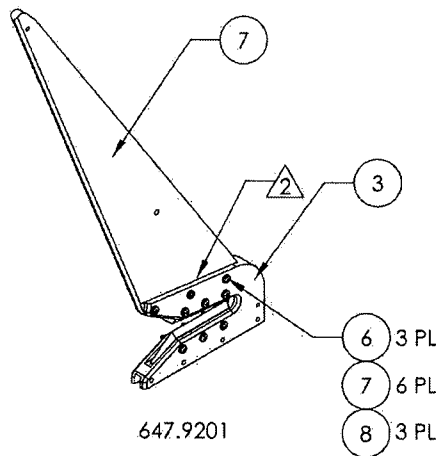
2. APPLY F/N 9 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 2, 3, 4, AND 7 UPON ASSEMBLY.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE RELEASE: PRI		N/C
2	INITIAL RELEASE	04-21-10	P. BRAVO

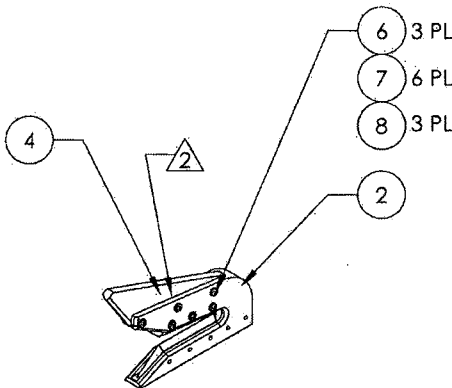
W/O 12/21/75



647.9203



647.9201



647.9202

A/R	A/R	A/R	9	601.2045	RTV	LOCTITE 598	
3	3	3	8	601.1541	LOCKNUT	MS21042L08	
6	6	6	7	601.2764	WASHER	NAS1149FNS32P	
3	3	3	6	601.2765	SCREW	MS27039-0B19	
		1	7	647.9411	UPPER DEFLECTOR		
		1	4	647.9410	LOWER DEFLECTOR		
		1	3	647.9702	UPPER CUTTER SUB		
1	1		2	647.9701	LOWER CUTTER SUB		
1			1	647.9402	LOWER DEFLECTOR		
				647.9203	LONG ASSY		
				647.9202	LONG ASSY		
				647.9201	LOWER CUTTER		
				647.9201	UPPER CUTTER ASSY		
.9203	.9202	.9201	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.

PARTS LIST			
QTY	DESCRIPTION	DATE	APPROVED
	ORIGINAL DATE (M/D/Y)	06-21-10	
	DRAWN BY	LOECER	
	A. QUAN	P. BRAVO	
	DRAWING APPROVAL		
	P. BRAVO	06-21-10	
	CONTRACT NO.		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°			
NEXT ASSY (S)			
647.8900			
APICAL INDUSTRIES			
2608 TEMPLE HEIGHTS DR.			
OCEANSIDE, CA. 92056-3512 (760) 724-5300			
CUTTER ASSY			
SHEET	CAGE CODE	DWG NO.	REV.
B	07MA26	647.9200	N/C
SCALE: NONE			SHEET 1 OF 1